

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011690**Date Inspected:** 14-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Mr. Wu Zhi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder( OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

**OBG TRIAL ASSEMBLY**

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) welding of weld joint CB202A-005-001. Welder is identified as 220067. ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables recorded by QC appeared to comply with the Applicable WPS: B-T-2232-TC-U5-F.

**SEGMENT-CB5**

Flux Cored Arc Welding (FCAW) welding of weld joint SSD27-PP038-221. Welder is identified as 220067. ZPMC Quality Control (QC) is identified as Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: B-T-2234-TC-U4b-F.

Shielded Metal Arc Welding (SMAW) welding of weld joint 006 located on CA027-006. Welder is identified as 066261. ZPMC Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with the Applicable WPS: B-P-2214-TC-U4b-FCM-1.

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## WELDING INSPECTION REPORT

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### SEGMENT-6CW

Shielded Metal Arc Welding (SMAW) welding of weld joint 008 located on FB035-001. Welder is identified as 066179. ZPMC Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with the Applicable WPS: B-P-2114-FCM-1.

### SEGMENT-5BE-5CE

Shielded Metal Arc Welding (SMAW) welding of repair weld joint OBE5-008. Welder is identified as 048659. ZPMC Certified Welding Inspector (CWI) is identified as Mr.Wu Zhi Cheng. The welding variables recorded by CWI appeared to comply with the Applicable WPS: WPS-345-SMAW-1G (1F) FCM-Repair and Critical Welding Repair (CWR) No: B-CWR-1045.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prabhu,Surendra	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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